still in evidence, this jig embodies most of the requirements necessary for rapid work. This design provides for integral clamping means within the jig itself, provided, in this case, by the screws /. The upper plate *K* is fastened to the walls of the lower plate *L* by four or more screws If and two dowel pins *N.* The cover *K* could also be put on, as shown in Fig. 5, by making the two parts a good fit at *0,* one piece being tonguecl into the other. This gives greater rigidity to the jig. In this jig, also, solid locating lugs *F* are used instead of pins.

Referring again to Fig. 4, by providing a swinging arm *P* with a set-screw *Q,* the work can be taken out and can be inserted

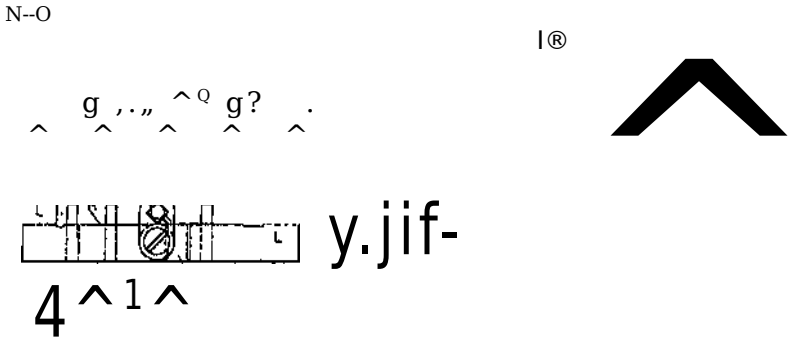

Fig. 4. Jig Suitable for MjimifueturinK Purposes

from the side of the jig, which will save making any provisions for taking off or putting on the top cover for every piece being drilled. If there is enough clearance between the top cover and the piece being drilled, the screw *Q* could, of course, be tnounted in a solid lug, but it would not be advantageous to have: so large a space between the top plate and the work, as the drill would have to extend unguided for some distance before it would reach the work. The set-screws *Q* and *U* hold the work against the locating points, and the set-screws *J* on the top of the jig, previously referred to, hold the work down on the finished pad *R* on the bottom plate. These screws also take the thrust when the hole *C* is drilled from the bottom side. It is immaterial on which side the bushings for guiding the drills for the two holes *A* are placed, but by placing them in the cover

rather than in